

# Work Order ID 103899

\*103899\*

Page 1

July-03-13 3:12:18 PM

Item ID: 647.1403

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Channel Ass'y, Upper U-Channel

Start Date: 7/03/13

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/04/13

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

647.1400

N/C

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

120

0.00

\*120\*

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 125306

exp. date: 12/14

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

Memo

0.00

Quality Control

5

Work Order ID 103899

\*103899\*

Page 2

July-03-13 3:12:18 PM

Item ID: 647.1403 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Channel Ass'y, Upper U-Channel  
 Start Date: 7/03/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 7/04/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
*140*									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

13-02-04

13/7/4

13-74

# Picklist Print

July-03-13 3:12:17 PM

Page 1

Work Order ID: 103899

Parent Item: 647.1403

Parent Item Name: Channel Ass'y, Upper U-Channel

Start Date: 7/03/13

Required Date: 7/04/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE JFS 13/07/03 VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.1541 LOCKNUT(MS21042L08) (8-32 THD) (CAD PLATED) (100 Q		Purchased	No			110	Each	0.0000	3	6		M123900 B 130204	
601.2764 WASHER (NAS1149FN832P)		Purchased	No			110	Each	0.0000	6	12		M123900 B 030204	
646.9702 Cutter Sub Assembly (U Channel)		Manufactured	No			110	Each	0.0000	1	2		B103901 B 130204	
647.1510 Upper Deflector		Manufactured	No			110	Each	11.0000	1	2		M125082 B 130204	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST139C		11							
				125082		11							
MS27039-08-19 Screw		Purchased	No			110	Each	2,257.0000	3	6		M125654 B 130204	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST307		89							
				123525		89							
				ST309		968							
				125654		968							
				st510		1200							
				124309		1200							

**APICAL**

INDUSTRIES, INC

ENGINEERING CHANGE NOTICE NO. 03911

SHEET 1 OF 1

DWG NO. 647.1400

REV: N/C

PREPARED  
BY:

J. BECKER

DATE: 06/07/13

EFFECT ON DWG  
☒ INC. ☐ UNINC.

DWG TITLE: CUTTER ASSY

APPROVED BY:

ENGR

MFG


QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):  
A-ADD C-CREATE  
R-REVISE D-DELETEREASON: ADDED CONFIGURATION 647.1403 AND INCORPORATED  
ECN 02962

w/ 103899

8	A	646.9702	1			CUTTER SUB ASSY (U CHANNEL)		
6	R	647.1510	1		1	UPPER DEFLECTOR		
5	R	601.2045	A/R	A/R	A/R	RTV, LOCTITE 598		
4	R	601.1541	3	3	3	NUT	MS21042L08	
3	R	601.2765	3	3	3	SCREW	MS27039-0819	
2	R	601.2764	6	6	6	WASHER	NAS1149FN832P	
	C	647.1403				CUTTER ASSY (UPPER U CHANNEL)		
F/N	TC	PART NUMBER	.1403	.1402	.1401	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY					
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED	
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

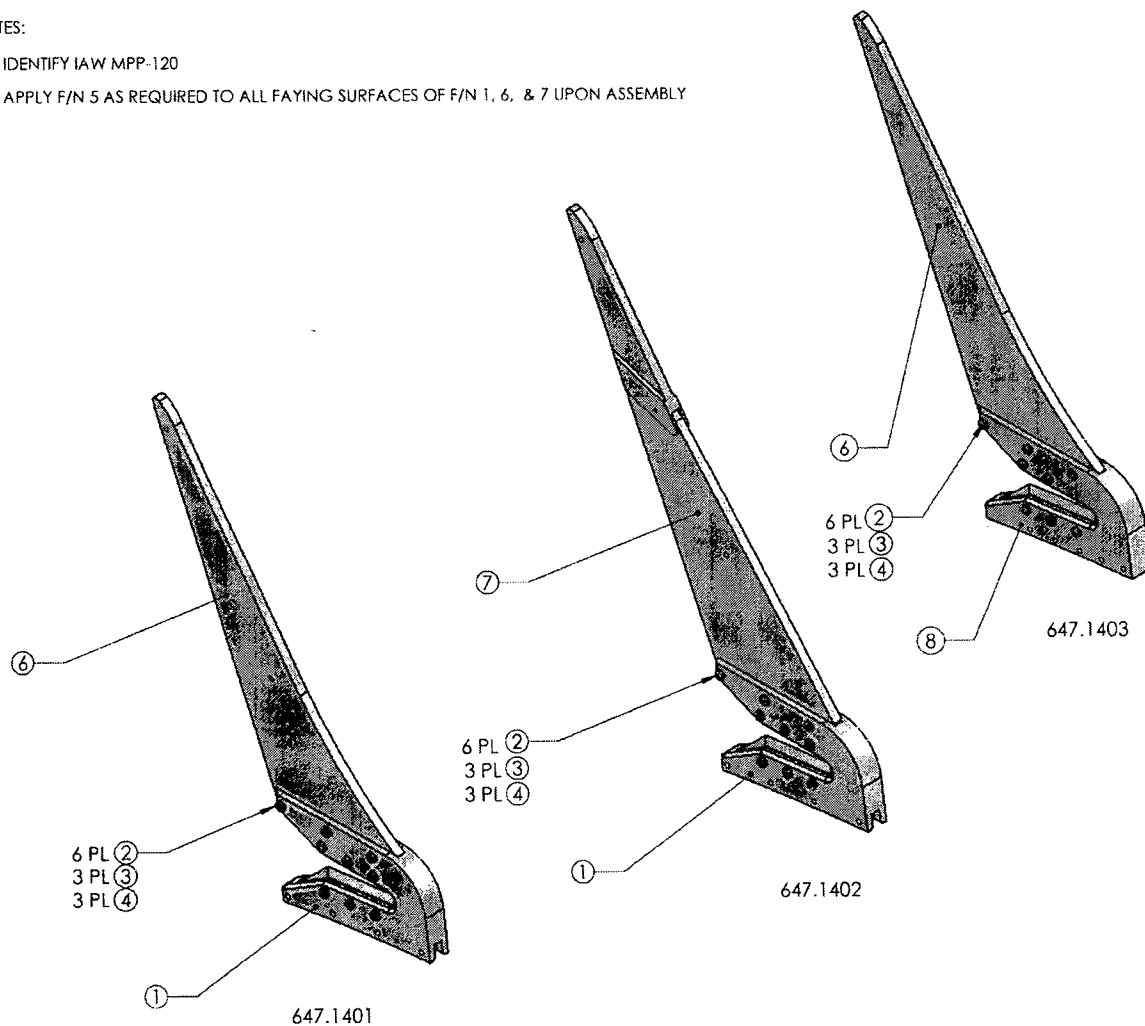
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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# NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION REVISION (P/P)		
2	INITIAL RELEASE	08/13/09	F. BRAYO
3	INCORPORATED ECN 10997 & 03911	04/07/13	F. BRAYO



1				B	646.9702	CUTTER SUB ASSY (U CHANNEL)		
	1			7	647.1501	LOWER DEFLECTOR ASSY		
1		1		6	647.1510	UPPER DEFLECTOR		
A/R	A/R	A/R		5	601.2045	RTV, LOCTITE 598		
3	3	3		4	601.1541	NUT	MS21042L08	
3	3	3		3	601.2765	SCREW	MS27039-0819	
6	6	6		2	601.2764	WASHER	NAS1149FN832P	
	1	1		1	646.9701	CUTTER SUB ASSY		
					647.1403	CUTTER ASSY (UPPER U CHANNEL)		
					647.1402	CUTTER ASSY (LOWER)		
					647.1401	CUTTER ASSY (UPPER)		
1403	1402	1401		FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY				PARTS LIST				
NEXT ASSY (S)				APICAL INDUSTRIES				
647.1300				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
				CUTTER ASSY				
				UNLESS OTHERWISE SPECIFIED: DIMENSIONS IN INCHES DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS DIMENSIONS 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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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